

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008236**Date Inspected:** 01-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Weing Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower & OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY#3

**Magnetic Particle Inspection**

This Q.A Inspector performed Magnetic particle Testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the Floor Beam Designation are as follows.

FB011-034-004, 010, 014, 23, 44, 22

FB011-037-004, 010, 013, 22, 23, 27

BAY # 5

**Visual Inspection**

This Q.A Inspector performed random Visual Testing of the area previously tested and accepted by ZPMC Quality control personnel. The members are identified as the Cable Tray Designation are as follows.

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CTS7 (A, B, C)

CTS8B (A, B, C, D, E)

CTS9 (A, B, C, D, E, F)

CTS11 (A, B, C, D)

BAY#3

The following green tags issued for OBG components after completing the NDT requirements are:

1. SSD12/12A-PP100-Green tag No-009613
2. SSD20/20A-PP101-Green tag No-009614

This QA Inspector randomly observed the following work in progress

BAY#02

FCAW welding process of weld joint 012 located on PCMK LD001-038. Welder is identified as 058245 ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F.

FCAW welding process of weld joint 005 located on PCMK LD002-038. Welder is identified as 215676 ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

BAY#01

FCAW welding process of weld joint 002 located on PCMK CW001B-PP052. Welder is identified as 251246 ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4B-F.

This QA Inspector also noted that the following Counter Weight fit up in progress.

CW001B-PP060

CW001B-PP076

BAY#03

FCAW welding process of weld joint 135 located on PCMK SSD18A-PP100. Welder is identified as 044824 ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4B-F.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

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## WELDING INSPECTION REPORT

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### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Utekar,Shrikant	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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